Dart Aerospace Ltd.
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Canada

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D2842-041
Job Sheet 215388

Part No: D2842-041 **Job Qty:** 2 pcs
Part Name: Step Assembly, LH, 206 Float

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 11/12/20 **Job Tracking No:**
Due Date: 12/3/20 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	**Large Fab - Steps - 1**	2 pcs			0.00	2.94	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		EC Nov30
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	**QC 5**	2 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		

Fg039

DAS 24 9-89

NOV 30 2020

DART AEROSPACE

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Container No: S316984

Part: D2842-041
Job No: 215388
Serial No/Batch: S316984
Revision: C
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/30/20

				QC 5 - 82	
120	**Large Fab - Steps - 2 - B4B**	2 pcs	0.00 6.90	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	CC Nov 30
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
130	**QC 9**	2 pcs	0.00 0.00	QC 9 - 10	
				QC 9 - 18 DAS	NOV 3 0 2020
				QC 9 - 24 24	
				QC 9 - 43 9-89	
				QC 9 - 50	
				QC 9 - 9	
140	**QC 5**	2 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22 DAS 24 9-89	NOV 3 0 2020
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150	**Handfinish - 1-1 Chemical-B4B**	2 pcs	0.00 0.74	Handfinish - 1 - 1 - B4B	BEB 04/12/2020
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
160 **QC 7**	2 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	DAS
			QC 7 - 50	50 DEC 0 4 2020
			QC 7 - 67	9-89
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
170 **Large Fab - Steps - 3 - B4B**	2 pcs	0.00 2.94	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	CC Dec.7
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
180 **QC 10**	2 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	DAS
			QC 10 - 24	24
			QC 10 - 43	DEC 0 7 2020 9-89
			QC 10 - 50	
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	

				QC 10 - 81	
190	**QC 5**	2 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	DAS 24 9-89
				QC 5 - 22	DEC 07 2020
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
191	**Handfinish - 2-1 Pressure-B4B**	2 pcs	0.00 0.74	Handfinish - 2 - 1 - B4B	BEB 08/12/2020
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200	**Powdercoat - 1 White Gl(A)-B4B** M254469. START: 11:45. OV.T: 390° FINISH: 12:15.	2 pcs	0.00 0.48	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	2012-8. DAS 34 9-89
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
210	**QC 3**	2 pcs	0.00 0.00	QC 3 - 10	DAS 15 9-89
				QC 3 - 13	
				QC 3 - 15	M 20-12-8
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	

				QC 3 - 87	
				QC 3 - 47	
220	**Handfinish - 4-1-Assembly-B4B**	2 pcs	0.00 0.74	Handfinish - 4 - 1 - B4B	MH 20-12-8
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
230	**QC 5**	2 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	DEC 11 2020
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	81
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
240	**Packaging 3-1 - Stock - B4B**	2 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B	69
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DEC 14 2020
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 **QC 21 - SA**	2 pcs	0.00 0.00	QC 21 - SA - 21	DAS 21 9 89 DEC 1 4 2020
			QC 21 - SA - 70	
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op Descriptions:
100 - (Fabricate per Drwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding
110 - (QC5- Inspect part completeness to step on W/O)
120 - (Weld per dwg A/R Aluminum rod Batch: 139104 1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")
130 - (QC9- Inspect visual per QSI004- Fusion Welds)
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (QC7-Inspect Chemical Conversion Coat)
170 - (Weld per dwg A/R Aluminum rod Batch:_____) 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.
180 - (QC10- Inspect visual per QSI004- ground welds)
190 - (QC5- Inspect part completeness to step on W/O)
191 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)***Touch up step with alodine per qsi 005 prior to powder coat***
200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
210 - (QC3- Inspect Part Finish)
220 - (Assemble as per dwg) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: S305285
230 - QC5- Inspect part completeness to step on W/O)
240 - (Identify as per dwg & Stock Location:_____)
250 - (QC21- Final Inspection - Work Order Release)

Job BOM

018550

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	S269726
D2734	Step End Plate	2 pcs (1 ea)	100-Large Fab - Steps - 1	S297921
D2734	Step End Plate	2 pcs (1 ea)	100-Large Fab - Steps - 1	S297921
D3459-1	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	S241255
D3459-3	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	S241312
MS27039C1-07	Screw	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	S247841
NAS1149C0332R	Washer (AN960C10L)	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	S301797
NAS1329C3KB130	Insert	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	S023251
NAS1515H3L	Washer	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	S247541

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	139	0
	D2734	4	109	0
	D3459-1	4	14	0
	D3459-3	4	19	0
220-Handfinish - 4-1-Assembly-B4B	MS27039C1-07	6	29	0
	NAS1149C0332R	6	3,012	0
	NAS1329C3KB130	6	36	0
	NAS1515H3L	6	124	0

Part Specifications

Specifications could not be found.

Plex 11/12/20 11:52 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled
☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up
☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: